

84093

Wednesday, May 02, 2012 2:38:31 PM

Setup Start *NS1*

Stop *NS2*

g

8

Run Start *NR1*

Stop *NR2*

Date:

**Insp.
Stamp**

Rev C

0.00

0.00

Packaging

0.00

0.00

Small Fab

1- assemble per dwg

0.00

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 84093***84093***

Page 2

Wednesday, May 02, 2012 2:38:32 PM

Item ID: D3499-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cable Guard Assembly

Start Date: 5/2/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

POP 81897

0.00

Packaging

83644

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/14

ME 12-06-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 02, 2012 2:38:35 PM

Page 1

Work Order ID: 84093

84093

Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-05-05 JLM
IPP Rev:B As per Rev B 06-08-31 JLM
per dwg revC DD 10.02.23 verified by:EC

IPP Rev:C as

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--------|--|-----------|----|--|--|-----|------|-----------|---|----|--|--|--|
| AN3C5A | | Purchased | No | | | 100 | Each | 1,328.000 | 2 | 16 | | | |
|--------|--|-----------|----|--|--|-----|------|-----------|---|----|--|--|--|

AN3C5A

Bolt

**

(8)

FF 12-0-14

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1321

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

220

121255

500

121444

500

16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, May 02, 2012 2:38:35 PM

Work Order ID: 84093

84093

Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 8.00

Required Qty: 8.00

AN3C6A

Purchased

No

100

Each

395.0000

3

24

AN3C6A

BOLT

**

(8) FF 12-06-14

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

394

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693

302

24

AN960C10L

NAS1149C0332

Purchased

No

100

Each

0.0000

10

80

*AN960C10I *

washer

D3499-2

Manufactured

No

100

Each

2.0000

1

8

D3499-2

Mounting Plate

**

(8) FF 12-06-14

**

(8) FF 12-06-14

Location

Loc Qty

Loc Code

ST207

2

44903

2

84097

8

Wednesday, May 02, 2012 2:38:35 PM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 02, 2012 2:38:35 PM

Page 3

Work Order ID: 84093

84093

Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 8.00

Required Qty: 8.00

D3499-3 Manufactured No

100 Each 10.0000 1 8

D3499-3

Plastic Cable Guard

**

(8) FF 12-06-14

Location

Loc Qty

Loc Code

ST207

10

75365

2

81541

8

8

D3499-5 Manufactured No

100 Each 15.0000 2 16

D3499-5

Placard

**

(8) FF 12-06-14

Location

Loc Qty

Loc Code

ST050

15

46759

3

81885

12

2

2

12

D3672-1 Manufactured No

100 Each 1,308.000 5 40

D3672-1

Phenolic Washer

**

(8) FF 12-06-14

Location

Loc Qty

Loc Code

ST060

1308

72229

4

76277

304

80369

500

83608

500

245

245

Wednesday, May 02, 2012 2:38:36 PM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 02, 2012 2:38:36 PM

Page 4

Work Order ID: 84093

84093

Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 8.00

Required Qty: 8.00

MS21043-3

Purchased

No

100

Each

1,009.000

5

40

MS21043-3

**

(8) FF 12-06-14

Nut

Location

Loc Qty

Loc Code

FG

~~0226~~

72

30

103691

72

GA

88

120693

88

ST301

849

118077

2

118614

67

118686

30

119758

20

121255

730

40

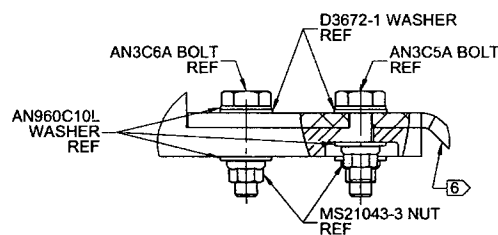
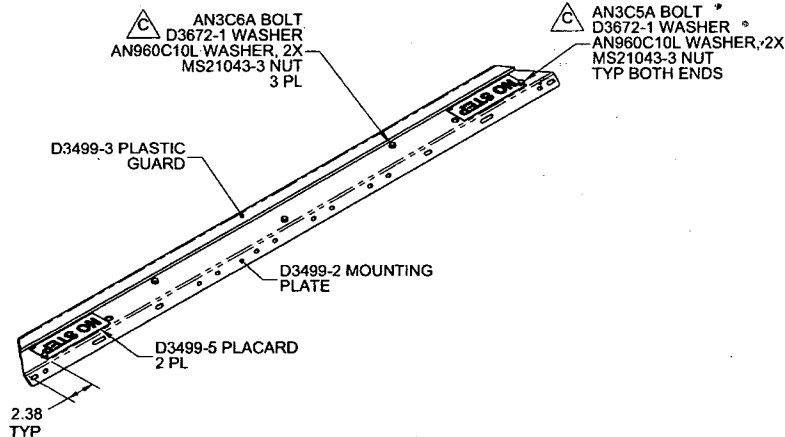
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

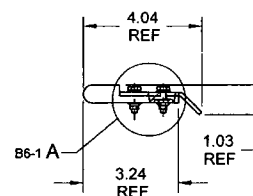
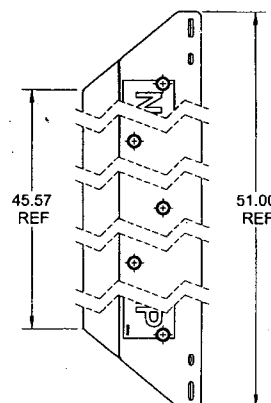
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| | | | | | | | | |

NOTE: Date & initial all entries



DETAIL A
B4-1
SCALE 4X



D3499-042 CABLE GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3499-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.90 lbs

| ITEM | QTY -042 | P/N | DESCRIPTION |
|------|-------------|-----------|----------------------|
| 1 | X | D3499-042 | CABLE GUARD ASSEMBLY |
| 2 | 1 | D3499-2 | MOUNTING PLATE |
| 3 | 1 | D3499-3 | PLASTIC GUARD |
| 4 | 2 | D3499-5 | PLACARD |
| 5 | 2 | AN3C5A | BOLT |
| 6 | 3 | AN3C6A | BOLT |
| 7 | 10 | AN960C10L | WASHER |
| 8 | 5 | MS21043-3 | NUT |
| 9 | 5 | D3672-1 | WASHER |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84093

RELEASED
2010-02-02
MD

| C | DRAWING UPDATED TO CURRENT STANDARDS. 3.245 WAS 3.255 (ZN B8-9); 3.24 WAS 3.25 (ZN D3-3); REVISE TOLERANCE & 2.01 WAS 2.00 (ZN D3-3); D3672-1 WAS NAS1515H3L (ZN D3-1, D5-1, D7-1); ADD IDENTIFY NOTE (ZN A8-1); REF NCR-09-045 | RF | 09.06.19 |
|------------|---|----|----------|
| B | RE-DESIGN D3499-2F/-3 | MB | 06.08.15 |
| A | NEW ISSUE | MB | 06.04.11 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | RF | | |
| CHECKED | RF | | |
| MFG. APPR. | RF | | |
| APPROVED | RF | | |
| DE APPR. | RF | | |
| DATE | 09.06.19 | | |

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3499** REV. C
SHEET 1 OF 4
TITLE **CABLE GUARD** SCALE NTS

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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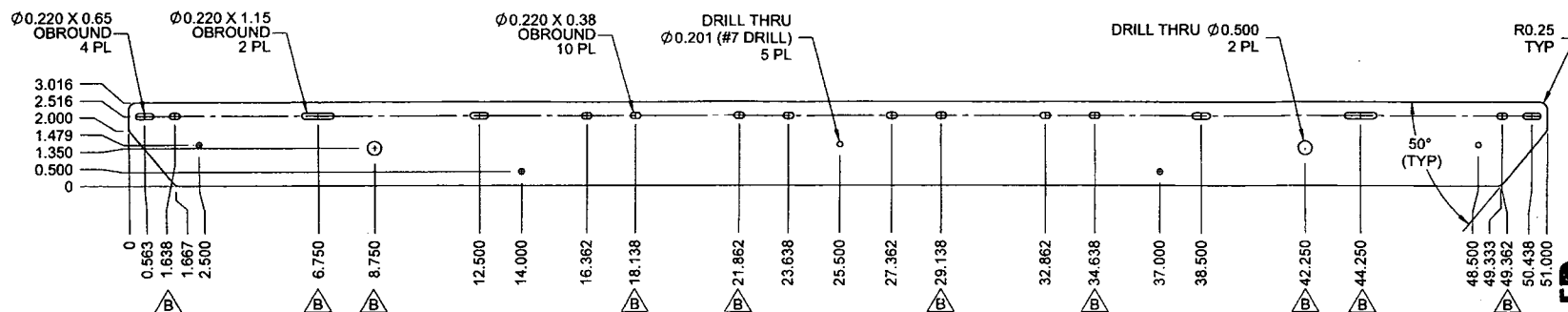
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

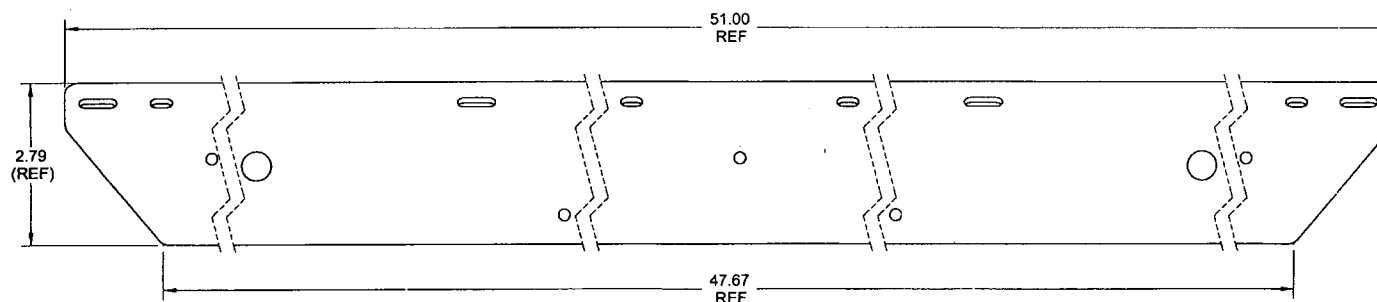
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NOTE: Date & initial all entries

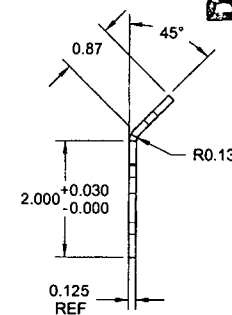
8 7 6 5 4 3 2 1



D3499-2F MOUNTING PLATE FLAT PATTERN
SCALE 0.5X



D3499-2 MOUNTING PLATE



D3499-2 BENDING DETAIL

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF: DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | B | DART AEROSPACE USA, INC. | |
| DRAWN | RF | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D3499 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CABLE GUARD | NTS |
| DATE | 09.06.19 | COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. | |
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R 2010-02-07

84093

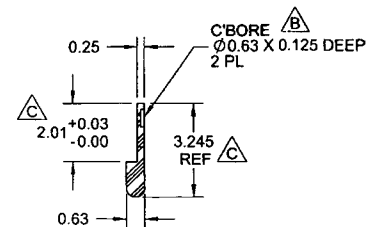
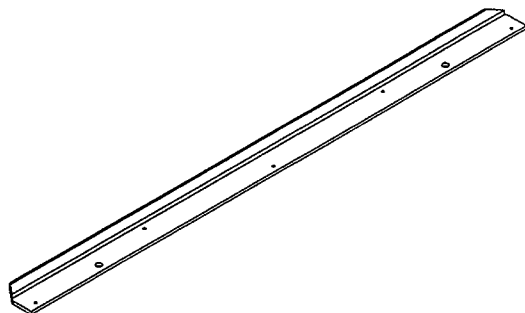
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

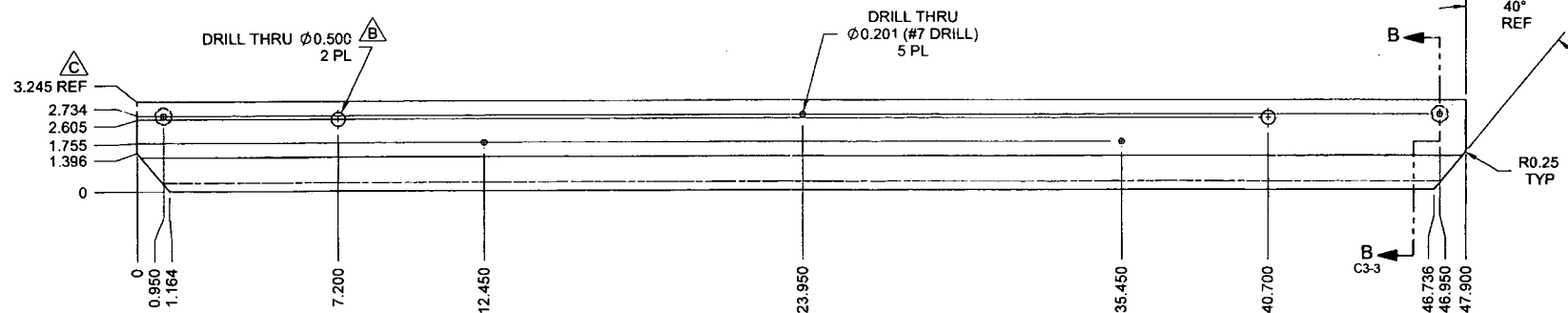
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



SECTION B-B B2-3



D3499-3 CABLE GUARD

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. MUHMWB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.52 lbs

84093

RELEASED
2010-02-02

| | | | |
|------------|----------|---|--------------|
| DESIGN | J | DART AEROSPACE USA, INC. | |
| DRAWN | RF | PORT HADLOCK, WA | |
| CHECKED | Q | DRAWING NO. | REV. C |
| MFG. APPR. | W | D3499 | SHEET 3 OF 4 |
| APPROVED | W | TITLE | SCALE |
| DE APPR. | W | CABLE GUARD | NTS |
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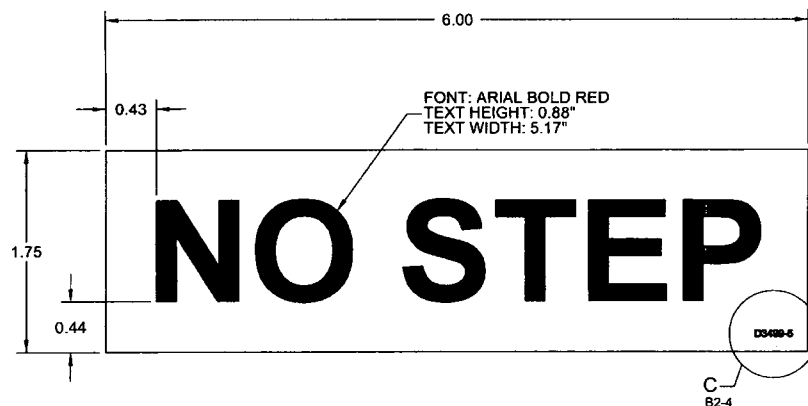
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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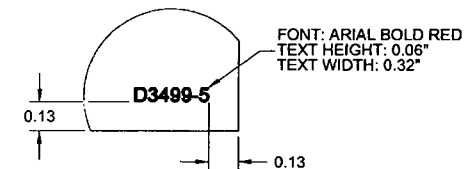
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| | | | | | | | | |

NOTE: Date & initial all entries



D3499-5 PLACARD



DETAIL C B5-4
SCALE 2X

NOTES:

- 1) MATERIAL: RED LETTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG" x 1.75" WIDE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

84093

RELEASED
2010-02-03
JMB

| | | | |
|---|----------|--|--------------|
| DESIGN | B | DART AEROSPACE USA, INC. | |
| DRAWN | RF | PORT HADLOCK, WA | |
| CHECKED | W | DRAWING NO. | REV. C |
| MFG. APPR. | J.A. | D3499 | SHEET 4 OF 4 |
| APPROVED | J.A. | TITLE | SCALE |
| DE APPR. | J.A. | CABLE GUARD | NTS |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries